

# Work Order ID 61229

August 11, 2010 11:07:18 AM



Page 1

Item ID:	D2939-2UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Right Side-unpainted					
Start Date:	8/11/10	Start Qty:	6.00		Cust Item ID:	
Required Date:	8/25/10	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/8/11</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2939	Rev C								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

ul 10.9.15

6

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

ul 10.9.15

6

0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

ul 10.9.15

6

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 61229

August 11, 2010 11:07:18 AM



Page 2

Item ID: D2939-2UP

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 Saddle Right Side-unpainted

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		A.A 10/09/16		6	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00		=> M 10/09/17		6	0		
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		BR 10-9-17		6	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61229**

August 11, 2010 11:07:18 AM



Page 3

Item ID: D2939-2UP

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 Saddle Right Side-unpainted

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Identify as per dwg &amp; Stock Location: 4311

0.00

Memo

0.00

Packaging

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/09/10 (6)

10/09/21

ME

10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

August 11, 2010 11:07:18 AM

Page 1

Work Order ID: 61229



Parent Item: D2939-2UP



Parent Item Name: 206 Saddle Right Side-unpainted

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001

Manufactured

No

100

Each

41.0000

1

6



*Ref 10.9.15*

Saddle Billet

### Location

### Loc Qty

### Loc Code

MAT

36

46409

36

MAT40

5

46409

5

*6385 x 6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	61229
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	D2939-2
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		Page 1 of 1	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.123	.123	.123	.123	.123
B	0.100	0.140		.123	.123	.123	.123	.123
C	0.100	0.140		.130	.130	.130	.130	.130
D	0.210	0.230		.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.237	.237	.237
N	0.100	0.140		.117	.117	.117	.117	.117
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.744	2.744	2.744	2.744	2.744
S	0.240	0.270		.250	.250	.250	.250	.250
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.256	1.256	1.256	1.256	1.256
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> <i>RF</i>	<b>Date:</b> 10.9.15
<b>Audited by:</b> <i>A.A</i>	<b>Date:</b> 10/09/16
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	61229
<b>Description:</b> 206 Saddle, Inboard, Right side		<b>Part Number:</b>	D2939-2
<b>Inspection Dwg:</b> D2939 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>		<b>Page 1 of 1</b>	

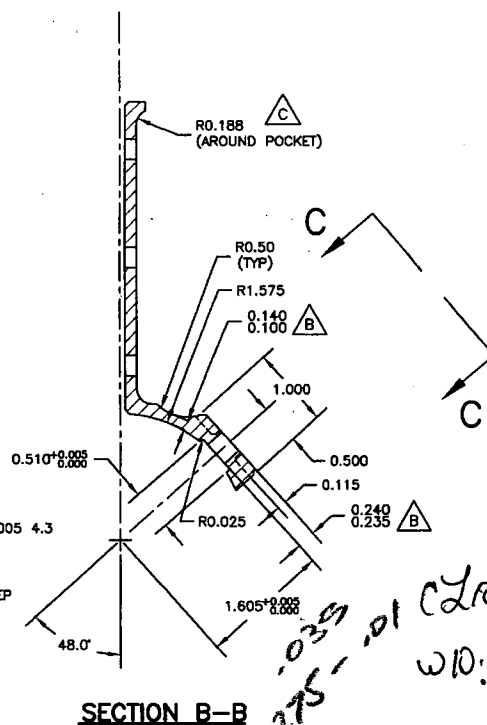
### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.123	Vernier	RQ-02		
B	0.100	0.140		.123				
C	0.100	0.140		.120				
D	0.210	0.230		.280				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.510				
I	1.572	1.582		1.577				
J	2.495	2.505		2.500				
K	0.257	0.262		.258				
L	0.312	0.317		.314				
M	0.235	0.240		.237				
N	0.100	0.140		.117				
O	0.540	0.560		.550	Micrometer	RQ-06		
P	0.490	0.510		.500	Vernier	RQ-02		
Q	3.715	3.725		3.720				
R	2.720	2.760		2.744				
S	0.240	0.270		.250				
T	0.100	0.180		.140				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.250	1.270		1.256	Height gage	31006		
Y	1.565	1.585		1.575	"			
Z	0.178	0.198		.180	Rad gage			
AA								
AB								
AC								
AD								
Accept/Reject								

<b>Measured by:</b> <i>[Signature]</i>	<b>Date:</b> 10-9-15
<b>Audited by:</b> <i>[Signature]</i>	<b>Date:</b> 10/09/16
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	<i>[Signature]</i>



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C	06.11.09	R0.188 WAS R0.30 TO R0.25	
B	00.05.29	CHANGED GEOMETRY AND MATERIAL	
A	99.11.12	NEW ISSUE	
DESIGN	<b>A</b> DRAWN BY	<b>DART</b>	DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED <b>PH</b>	DRAWING NO. D2939	REV. C SHEET 1 OF 1
DATE	06.11.09	TITLE SADDLE INSIDE	SCALE 2:3